

**Work Order ID 76209****\*76209\***

Page 1

Monday, November 07, 2011 2:42:01 PM

Item ID: D3389-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 11/7/2011 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:     Date: 11-11-07Tooling:     Date:     Run Start **\*NR1\***QC:     Date:     SPC (Y/N):     Date:     Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

**Draw Nbr****Revision Nbr**

D3389

Rev D

100

0.00

**\*100\***

Skidtubes

Skidtubes

**Memo**

0.00

Skidtubes

1- Pick D2500-3-100  
2- Deburr  
3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.  
4- Cut to finished length  
5- Open holes to finished size as per dwg D3389  
6- Deburr

110

QC6- Inspect dimensions to drawing

0.00

**\*110\***

QC

**Memo**

0.00

Quality Control

6

BE 11-12-01

6 0 BE 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76209

**\*76209\***

Page 2

Monday, November 07, 2011 2:42:01 PM

Item ID: D3389-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 11/7/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 11/16/2011 Req'd Qty: 6.00 **\*6\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>6</u>			<u>B 11/12/01</u>
130 <b>*130*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>6</u>	<u>0</u>		<u>BE 11-12-01</u>
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>L9</u>  Memo	0.00  0.00				<u>6</u>			<u>B 11/12/01</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*76209\***

Monday, November 07, 2011 2:42:01 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/7/2011      **Start Qty:** 6.00

\*6\*

**Cust Item ID:****Required Date:** 11/16/2011      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

11/2 / 1 20

mf  
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 07, 2011 2:42:04 PM

Page 1

Work Order ID: 76209

\*76209\*

Parent Item: D3389-1

\*D3389-1\*

Parent Item Name: Web

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 6.00

Required Qty: 6.00

## Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-02-08 As per Rev C JLM

IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2500-3-100

Manufactured

No

100

Each

84.0000

1

\*D2500-3-100\*

\*\*

6

3 4/12/11

Ext'n - I Beam Web 4"

## Location

## Loc Qty

## Loc Code

LG

84

51957

2

66298

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

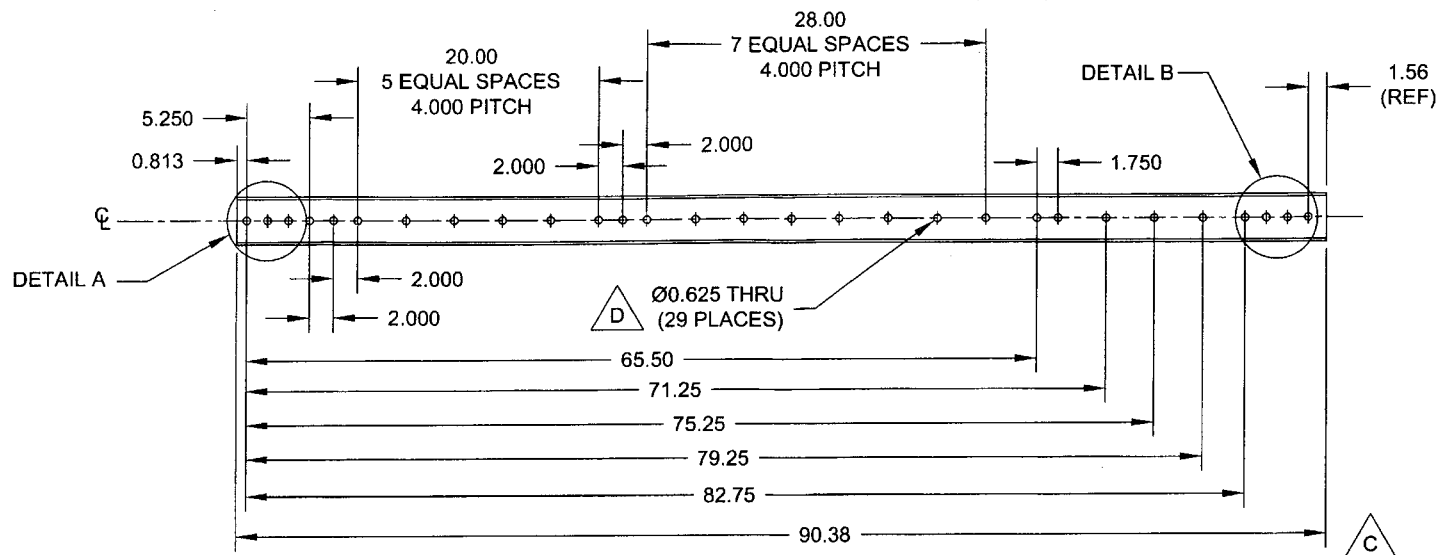
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

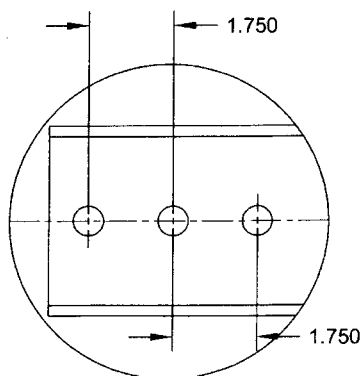
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

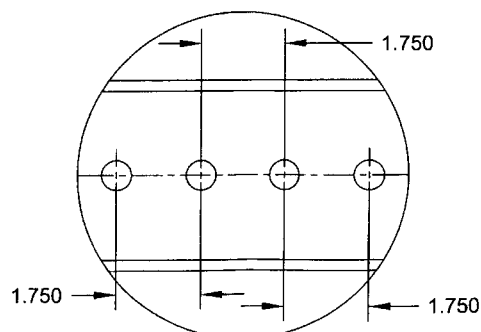




**D3389-1 412 WEB**



**DETAIL A**  
SCALE 2:5



**DETAIL B**  
SCALE 2:5

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76209

- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 6.6 lbs

**RELEASED**  
07.11.06 MJD

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3389 REV. D SHEET 1 OF 1

TITLE 412 WEB SCALE 1:10

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries